



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3300-20
Job Sheet 172923



Part No: RBE350A93-3300-20

Job Qty: 6 ea

Part Name: T/R Hub Socket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/23/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3300-20 REV:3 IPP REV:A 18.01.15 NEW ISSUE RQ VERIFIED BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/26/18	0.00	0.00	Start Up Machining-4		
100	CNC Lathe	6 pcs		2/27/18	0.00	0.30	MORI SL2500Y		
110	QC	6 pcs		2/27/18	0.00	0.00	QC2		
120	QC	6 pcs		2/27/18	0.00	0.00	QC8 Machining-3		38-18-03-08
130	Outsource	6 pcs		2/27/18	0.00	0.00	Outsource12	PO 039313	CT 18-03-20 AT 18/03/24
140	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging2		38
145	QC	6 pcs		2/27/18	0.00	0.00	QC6		9-00
150	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3-2		DAS
160	QC21-FG	6 Ea		2/27/18	0.00	0.00	QC21		21

Part Op 100 - 1-Machine as per folio FB748 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Descriptions: 110 - 1-Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

130 - -Issue P/O to Groupe Altech; PO 09313 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
J07540M	Socket	6 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	J07540M	6	1	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

be found.

Plex 2/23/18 8:25 AM Dart.lajeunesse.marie

Container No: S048052



Part: RBE350A93-3300-20

Job No: 172923

Serial No/Batch: S048052

Revision: 3

Inspector:

AML 3-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

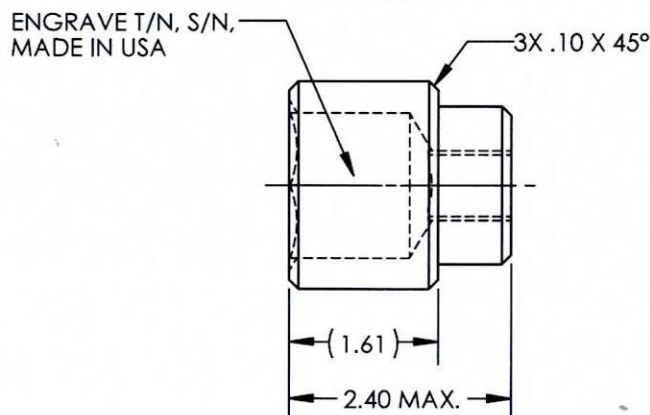
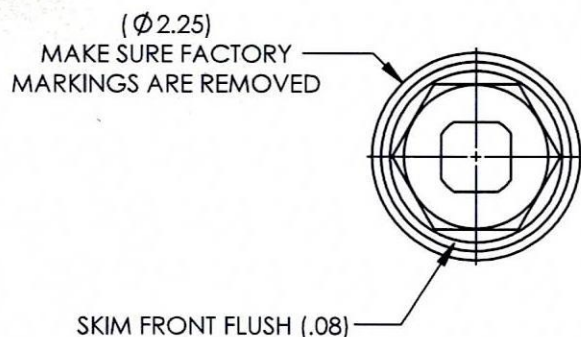
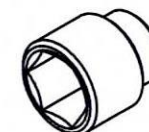
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D DIM WAS Ø2.11 IS Ø2.10 - 2.08, ADDED MAKE SURE FACTORY MARKINGS ARE REMOVED AND MADE IN USA.	4/29/2009	RJC	
2		ADDED CHAMFERS AND CH'D FROM A 1-9/16in. 1/2 in. DRIVE SOCKET TO A 40mm 3/4 in. DRIVE SOCKET PER HELI-PRODUCTS STOCK. ALSO CH'D UPPER O.D. TOLERANCE WAS Ø2.11 IS 2.2 TO ACCOMMODATE 40mm SOCKET PER DW.	9/29/2009	WP	
2A		CH'D T/N WAS RBEA93-3300-20 ISA RBE350A93-3300-20.	6/19/2013	BIM	RW
3	15-0147	CH'D BUYOUT INFO WAS SNAP-ON IS PROTO. CH'D OAL WAS (2.23) IS 2.40 MAX. CH'D DIM WAS Ø2.10 - 2.08 IS (Ø2.25). ADDED NOTE 1. CORRECTED ORIGINAL No. REF. WAS RBEA93-3302-02 IS RBEA93-3300-20.	6/24/2015	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170566 MJS

1801-17



ORIGINAL No. REF.
DO NOT USE FOR REF. ONLY
RBEA93-3300-20 = 350A93-3300-2.

NOTE:
1. PART OF AGUSTA KIT RBEA62309.

DART AEROSPACE	
TITLE TAIL ROTOR HUB SOCKET	
DWG NO. RBE350A93-3300-20	REV 3
MAT'L STEEL	DRAWN BY: PERRITT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT FINISH BLACK OXIDE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC USED ON MODEL AS350A
SCALE 1:2	DATE 3/19/2009
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	SOCKET	STEEL	40mm -6 POINT 3/4 in. DR. (PROTO #J07540M) MODIFIED	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039313**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039313
PO Date: 3/14/18
Due Date: 4/6/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	172430	269T9281	Wrench, Splined Fitting HEAT TREAT TO RC 25-32 1--Issue P/O to Metcore ; P/O _____ RC _____ 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech or ATG	Firmed	4/6/18	2 pcs	0 pcs	2 pcs	\$37.50/pcs	\$75.00
2	172923	RBE350A93-3300-20	T/R Hub Socket -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/6/18	6 pcs	0 pcs	6 pcs	\$3.87096774/pcs	\$23.23
3	170584	RBE350A94-3700-A-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/6/18	19 pcs	0 pcs	19 pcs	\$3.87096774/pcs	\$73.55
4	169801	RBW109-3130-83-111-1	Weldment Black oxide	Firmed	4/6/18	6 pcs	0 pcs	6 pcs	\$3.87096774/pcs	\$23.23
Grand Total:										\$195.00

Order Notes

CL



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007612- 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
21-Mar-2018		Curtis Anderson				PO039313			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
2	RBE350A93-3300-20 Rev.	RBE350A93-3300-20 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0	
3	RBW109-3130-83-111-1 Rev.	RBW109-3130-83-111-1 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	6	6	0	0	0	
4	RBE350A94-3700-A-01 Rev.	RBE350A94-3700-A-01 01 -OXIDE BLACK [OXIDE BLACK]	BLACK-OXIDE CH	19	19	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.